

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010351**Date Inspected:** 19-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Yumin**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, M.Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD

This QA inspector witnessed final tension verification for U-Rib continuity plate of Lift 1 East. Witnessed 10% on a random basis the bolts and found the tension to be in general compliance. The panel point and bolt size designations are as follows:

PP-9.5, 10.5, PP-11, PP11.5 & PP12: M24 X 70 – DHGM 240003 – 543 NM

PP-10.5: M24 X 60 – DHGM 240014 – 567 NM

OBG # TRIAL ASSEMBLY YARD (Lift 1 West)

Caltrans Quality Assurance (QA) inspector observed at elevation 1800mm of Lift 1 West (PP8.5 to PP12.5), Floor beam plate (X15SK) to Longitudinal Stiffener plate (X157FA) connected with fasteners were not tension verified.

OBG # TRIAL ASSEMBLY YARD (Lift 1 West)

Caltrans Quality Assurance (QA) inspector observed at Traveler Rail bracket installed at Lift 1 West - PP 10, 11 and 12 fasteners were not tension verified.

This QA Inspector randomly observed the following work in progress:

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OBG # TRIAL ASSEMBLY YARD (6AE-6BE)

SMAW Process:

Welding of weld joint-027 between T-Rib to T-Rib CJP located on PCMK SP334-001 side panel of 6AE to 6BE. Welder is identified as 067571. ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-P-2213-B-U2-FCM-1.

FCAW Process:

Welding of weld joint-034 between T-Rib to T-Rib CJP located on PCMK SP307-001 side panel of 6AE to 6BE. Welder is identified as 220067. ZPMC CWI is identified as Xu Yumin. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U2-F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

The incident report is issued for the above mentioned discrepancy observed in Lift 1 West. And prior to issue it was informed to ZPMC QC and ABF QA.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
